

# Work Order ID 84012

**\*84012\***

Page 1

May-01-12 10:41:24 AM

Item ID: D2435

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw, 206

Start Date: 01/05/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/10 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2435	Rev E1
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(12)

120

0.00

**\*120\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

UHMW 1" Blk.

B12-5-29

130

0.00

**\*130\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435  
3-Deburr

H/8

12-04-28

(x12)

140

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12-04-28 (x12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 84012

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Page 2

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Item ID: D2435

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bearpaw, 206

Start Date: 01/05/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

Quality Control

B.A 12/06/30

12

0

151

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*151\***

Packaging

Memo

0.00

Packaging

2x 86 551  
10x 86 337

12/1/06 (12)

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

OK 12/7/09

MF  
12-07-06

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**NOTE:** Date & initial all entries

# Picklist Print

May-01-12 10:41:31 AM

Page 1

Work Order ID: 84012

\*84012\*

Parent Item: D2435

\*D2435\*

Parent Item Name: Bearpaw, 206

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 12.00

Required Qty: 12.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	231.2100	3.2	38.4			

\*MUHMWB10\*

\*\*

1812-5-29

UHMW 1" Black

### Location

### Loc Qty

### Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

199.6099947

121277

12.8

121278

186.809995

121851

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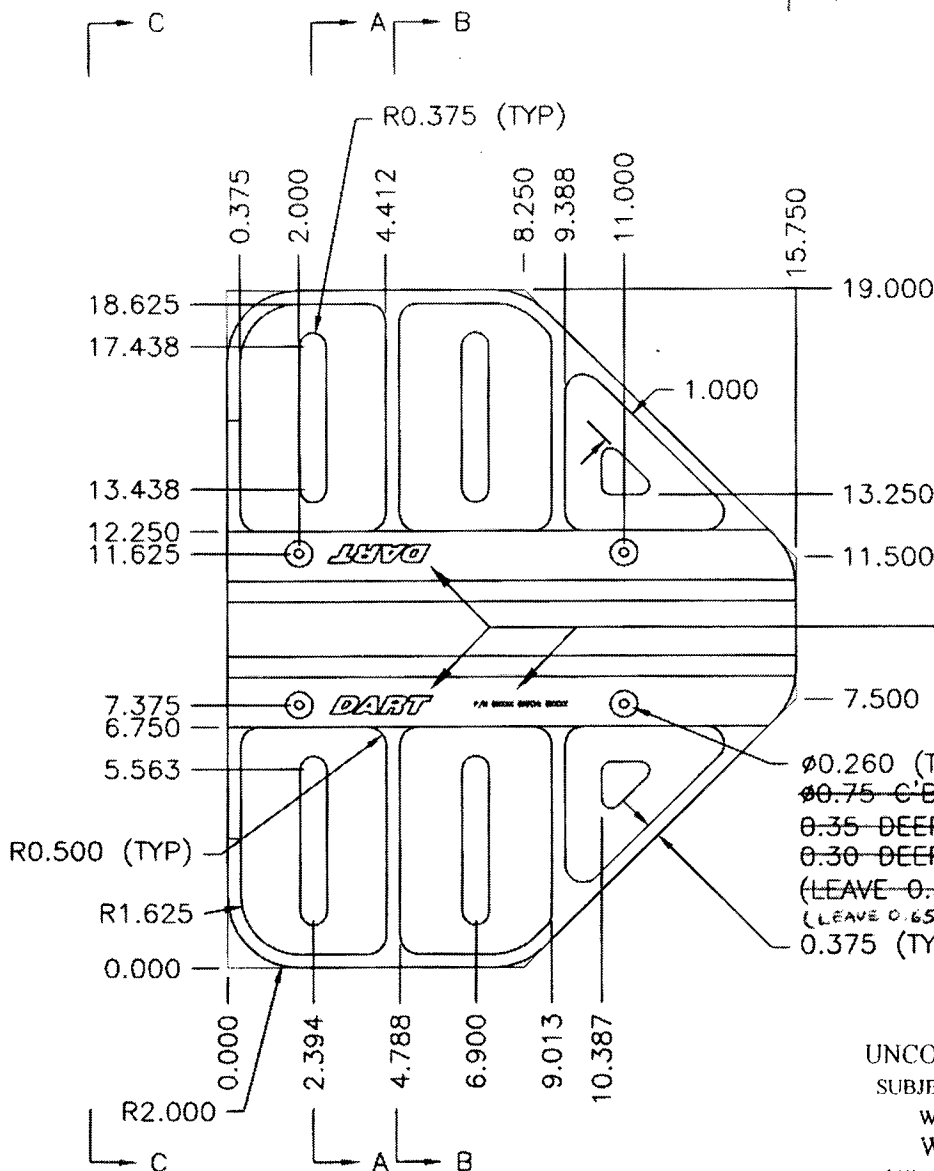
**NOTE:** Date & initial all entries



RELEASED  
98.06.17 KE

DESIGN	DRAWN BY	DART Aerospace Ltd HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED KE	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



EN  
E  
E  
SHORE COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84012 MJS  
12/05/01

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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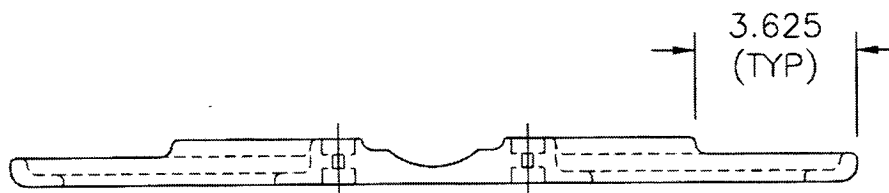
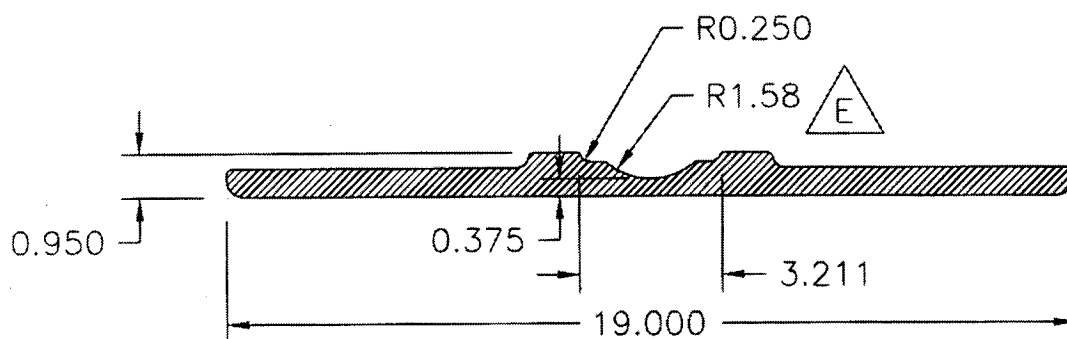
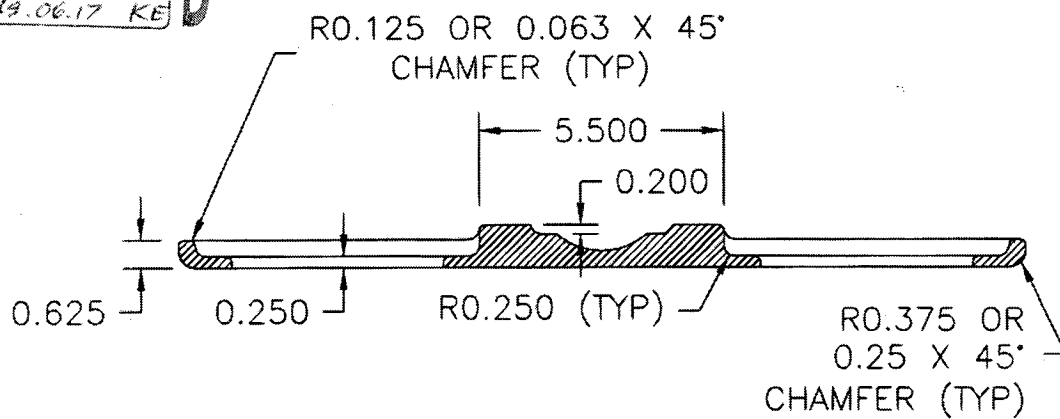
**NOTE:** Date & initial all entries





DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



84012

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	84012
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.083	✓		vern	RT-4
B	5.500	+/-0.030	5.503	✓		"	
C	0.200	+/-0.030	.194	✓		depth gauge	RT-6
D	R0.250	+/-0.030	.250	✓		rad gauge	
E	0.250	+/-0.010	.260	✓		vern	RT-4
F	0.625	+/-0.030	.640	✓		"	
G	0.25 x 45°	+/-0.030	.256	✓		"	
H	0.375	+/-0.010	.384	✓		"	
I	19.000	+/-0.030	19.000	✓		"	
J	0.950	+0.030/-0.010	.962	✓		"	
K	Ø0.260	+0.005/-0.000	.260	✓		"	
L	Ø0.930	+/-0.030	.926	✓		"	
M	0.30	+0.030/-0.000	.310	✓		depth gauge	RT-6
N	0.375	+/-0.030	.384	✓		vern	RT-4
O	7.375	+/-0.030	7.375	✓		"	
P	4.250	+/-0.010	4.253	✓		"	
Q	2.000	+/-0.030	2.016	✓		"	
R	9.000	+/-0.010	9.000	✓		Tape	RT-10
S	15.750	+/-0.030	15.750	✓		Tape	RT-10

Measured by: <u>RT</u>	Audited by: <u>B.A</u>	Prototype Approval:	N/A
Date: <u>02-06-24</u>	Date: <u>12/06/30</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <u>TF</u>	<u>TF</u>

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